

17/09

Work Order ID 107035

107035

Page 1

September-16-13 11:17:26 AM

Item ID: D4664-7

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Spacer

Start Date: 9/16/13

Start Qty: 50.00

50

Cust Item ID:

Required Date: 9/18/13

Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan: *✓*

Date: _____

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4664

C

100

0.00

100

Hardinge

Hardinge CNC LATHE SMALL

0.00

Hardinge CNC Lathe Small

Memo

1-Turn as per Folio and dwg

Folio Rev: *N/C*

Dwg Rev: *C*

-Deburr

OK 13/09/16

52 10

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Quality Control

Memo

OK 13/09/16

52 10

D45

Work Order ID 107035***107035***

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September-16-13 11:17:26 AM

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

52 _____ SL13-9-16

122

Chemical Conversion Coat per QSI005 4.1

0.00

122

HandFinish

Memo

0.00

Hand Finishing

52 _____ W.W. 13-9-16

126

QC7-Inspect Chemical Conversion Coat

0.00

126

QC

Memo

0.00

Quality Control

52 X P M. 13/09/16

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Item ID: D4664-7

Accept

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: ST 119

0.00

130

Packaging

Memo

0.00

Packaging

52x

D4
13-9-17

13-9-17

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 13-09-17

MLJ 13-09-17

Picklist Print

September-16-13 11:17:26 AM

Page 1
J

Work Order ID: 107035
Parent Item: D4664-7
Parent Item Name: Spacer

Start Date: 9/16/13
Start Qty: 50.00

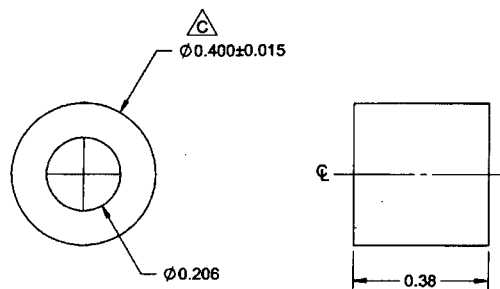
Required Date: 9/18/13
Required Qty: 50.00

Comments: IPP REV:A NEW ISSUE 12-11-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500 6061-T6 Round Bar .500"		Purchased	No				f	49.8190		1.6842105			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT012	49.819	
114488	3.994	
123483	1.238	
124029	0.6	
124681	14.957	
125552	29.03	

1.7 ~~84~~ *on 13/09/16*



D4664-7 SPACER



NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. C
MFG. APPR.	NS	D4664	SHEET 4 OF 4
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	SPACER	NTS
DATE	13.06.18	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

RELEASED
2013-07-15

